

5/04007



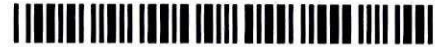
Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

DAS  
13  
9-89

JUN 22 2018

**D2622-120C**  
**Job Sheet 179413**



Part No: D2622-120C

Job Qty: 240 ea

Part Name: Step Extrusion



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/19/18

Job Tracking No:

Due Date: 7/16/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV C1

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation  | Qty     | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off        |
|-------|------------|---------|------------|----------|-----------|---------|-----------------------|-----------|-----------------|
|       |            |         |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                 |
| 100   | Purchasing | 240 pcs | 7/16/18    | 7/16/18  | 0.00      | 0.00    | Purchasing            |           | AT AUG 21 2018  |
| 110   | Packaging  | 240 pcs | 7/16/18    | 7/16/18  | 0.00      | 0.00    | Packaging2            |           | AT AUG 21 2018  |
| 120   | QC         | 240 pcs | 7/16/18    | 7/16/18  | 0.00      | 0.00    | QC18                  |           | AT AUG 21 2018  |
| 130   | Packaging  | 240 pcs | 7/16/18    | 7/16/18  | 0.00      | 0.00    | Packaging3-1          |           | SKL AUG 21 2018 |
| 140   | QC21-SA    | 240 Ea  | 7/16/18    | 7/16/18  | 0.00      | 0.00    | QC21                  |           | 21 AUG 21 2018  |

Part Op 100 - Issue P/O: 40296 a) Extrude as per Dwg D2622 Rev. C f) Order at 120" longg) Bon L Canada Inc.  
Descriptions: 110 - Ensure material certification is attached

120 - Check Pull test per Dwg D2622 for compliance page attached Check hardness with Webster tester

130 - LOCATION : HALL

DAS  
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9-89

JUN 22 2018

X 241

### Job BOM

| Part / Item | Component Name | Quantity       | Operation      | Container |
|-------------|----------------|----------------|----------------|-----------|
| D2622-120CP | Extrusion      | 240 pcs (1 ea) | 100-Purchasing | 5/04003   |

### Job Allocations

| Operation      | Component Part | Required | Inventory | Allocated |
|----------------|----------------|----------|-----------|-----------|
| 100-Purchasing | D2622-120CP    | 240      | 0         | 0         |

### Part Specifications

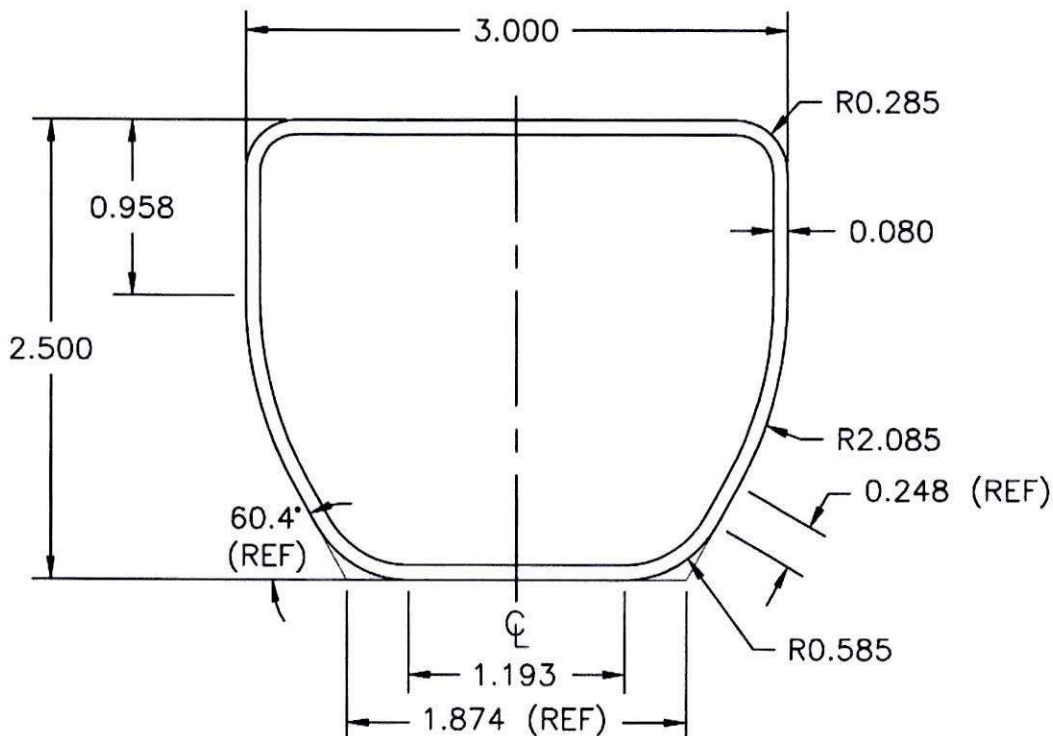
Specifications could not be found.

Plex 6/19/18 7:53 AM dart.lavoie.chantal



|                        |                         |                                                   |                        |
|------------------------|-------------------------|---------------------------------------------------|------------------------|
| DESIGN<br>KE           | DRAWN BY<br>CP          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>[Signature] | APPROVED<br>[Signature] | DRAWING NO.<br>D2622                              | REV. C<br>SHEET 1 OF 1 |
| DATE<br>02.09.11       |                         | TITLE<br>STEP EXTRUSION                           | SCALE<br>1:1           |
| A                      | 96.11.29                | NEW ISSUE                                         |                        |
| B                      | 97.12.12                | CHANGE MATERIAL, ADD TOL. QSI                     |                        |
| C                      | 02.09.11                | 0.080 WAS 0.085; ADD PART & DIE No.               |                        |
| CI                     | CP 02.10.04             | ADD 'REV. A' TO DIE NUMBER.                       |                        |

RELEASED  
02.09.11 *off*



1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES  
(EG. D2622-120 IS 120" LONG)

2) MATERIAL 6061-T6 (QQ-A-200/8)

3) MANUFACTURED USING BON-L DIE # 897123 REV. A 

4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi

MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi

MINIMUM ELONGATION = 8%

5) PART IS SYMMETRIC ABOUT CENTERLINE

6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# **PURCHASE ORDER** **PO040296**

**Supplier:** SIG001-VC  
Signature Aluminum Canada Inc.  
C/O/ T10322C  
PO Box 4488, STN A  
TORONTO  
ON  
M5W 4H1 Canada  
Phone: 905-427-6550  
Fax: 905-427-2246

**PO No:** PO040296

**PO Date:** 6/22/18

**Due Date:** 8/13/18

**Purchase Order**  
**Revision:**

**Revision Date:**

**Ship-To Contact:** Lavoie, Chantal  
clavoie@dartaero.com

**E-MAILED**

**JUN 22 2018**

**Ship To:** 1270 Aberdeen Street  
Hawkesbury  
ON  
K6A 1K7 Canada  
Phone: 613-632-5200

**Via:** Ground

**Pymt Terms:** Net 30

**Freight Terms:**

**Special Comments:** QUOTE NO. 06202018-009

## **Items**

| Line Item | Job    | Part        | Supplier Part No | Description                                                                                                                                                                                                                                                                                                         | Status | Due Date | Order Quantity | Received Quantity | Balance | Unit Price (CAD) | Extended Price |
|-----------|--------|-------------|------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|----------|----------------|-------------------|---------|------------------|----------------|
| 1         | 179423 | D2423P      |                  | Lug Extrusion<br>: AS PER DWG D2423 REV.<br>B ( EXTRUSION CUT AT 8<br>FT LONG )<br>die # DAA-5-2<br><br>EXTREME CARE MUST BE<br>TAKEN TO PROTECT THE<br>OUTSIDE SURFACE OF<br>THE OUTSIDE TUBE. THE<br>OUTSIDE SURFACE MUST<br>BE SMOOTH AND FREE<br>FROM SURFACE DEFECTS<br>SUCH AS<br>SCRATCHES,NICKS,OR<br>DENTS | Firmed | 8/13/18  | 288 ft         | 0 ft<br>328 ft    | 288 ft  | \$9.9248263/ft   | \$2,858.35     |
| 2         | 179413 | D2622-120CP |                  | Extrusion<br>: EXTRUDE AS PER DWG<br>D2622-120 REV. C<br>DIE # DAA- 897123<br>LENGHT 120"<br><br>EXTREME CARE MUST BE<br>TAKEN TO PROTECT THE<br>OUTSIDE SURFACE OF<br>TUBE<br>MATERIAL MUST BE<br>SMOOTH AND FREE FROM<br>DEFECT<br>SCRATCHES,NICKS,DENTS                                                          | Firmed | 8/13/18  | 241 pcs        | 0 pcs<br>251      | 241 pcs | \$24.542323/pcs  | \$5,914.70     |

**Grand Total: \$8,773.05**

## **Order Notes**

**Order Notes**

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

**Procurement Quality Clauses****A005 RIGHT OF ENTRY****A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)****A012 CHEMICAL AND PHYSICAL TEST REPORTS****A016 PERSONNEL QUALIFICATION****A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)****A026 CERTIFICATION OF MATERIAL CONFORMANCE****A041 QUALITY MANAGEMENT SYSTEM****A042 DART NOTIFICATION BY SUPPLIER****A043 RETENTION OF QUALITY DOCUMENT****A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM****A049 SUPPLIER AWARENESS***Plex 6/22/18 8:24 AM dart.lavoie.chantal*



Carrier: MCGILLION

TRL 222407

on 08/20/18

Shippers No: 038877

From: SIGNATURE ALUMINUM CANADA

1850 CLEMENTS ROAD

PICKERING ON L1W 3R8



ISSUED AT SHIPPER'S REQUEST

ÉMIS À LA DEMANDE DE L'EXPÉDITEUR

Received, subject to the classifications and tariffs in effect on the date of issue of this Original Bill of Lading, or received, subject to the Rules for the Carriage of Express and Non-Carload Freight Traffic and tariffs in effect on the date of issue of this Original Shipping Contract (Bill of Lading), goods described below, in apparent good order, except as noted, contents and conditions of contents of packages, unknown, marked, consigned and destined as indicated below, which said Company agrees to carry to its usual place of delivery at said destination, if on its road, otherwise to deliver to another carrier on the route to said destination. It is mutually agreed, as to each carrier of all or any of said goods over all or any portion of said route to destination, and as to each party at any time interested in all or any of said goods, that every service to be performed hereunder shall be subject to all the terms and conditions (which are hereby incorporated by reference and have the same force and effect as if the same were severally, fully and specifically set forth herein):

1. Railway Traffic Liability Regulations (S.C.R. 91-468 August 14, 1991) passage of the National Transportation Act, 1987;
2. of the bill of lading of the water carrier as provided in its tariffs of rules and Regulations when said goods are carried by a water carrier, or
3. of the bill of lading set forth in or prescribed by the relevant tariffs, classification, statutes and regulations pertaining to motor carriers services when said goods are carried throughout by a motor carrier, or
4. of the bill of lading in Schedule 2 by D.C. 47-88 of January 18, 1988 when said goods originating in Quebec are to be carried by a motor carrier
5. or approved by the Board of Transport Commissioners for Canada by General Order No. T-43, set forth in the Rules for the Carriage of Express and Non-Carload Freight Traffic and also available at all express and railway agency stations and express and freight offices upon request, when said goods are carried by a rail carrier, and which are agreed to by the shipper and accepted for himself and his assigns.

Reçu, sous réserve des classifications et tarifs en vigueur à la date de livraison de ce connaissance original ou sous réserve des règlements régissant le transport des messageries et marchandises de détail et des tarifs en vigueur à la date de livraison de ce contrat de transport (connaissance), les marchandises désignées ci-dessous, apparemment en bon état, sauf les remarques contenues aux présentes (le contenu et l'état du contenu des colis étant inconnus), marquées et consignées tel que ci-après indique, et que la Compagnie s'engage à transporter à destination à son lieu habituel de livraison, pourvu que telle destination soit sur son parcours, sinon à les livrer à un autre voiturier faisant route vers cette destination. Il est de plus convenu que tout voiturier transportant tout ou partie desdites marchandises sur tout ou partie du parcours, que toute personne intéressée en aucun temps à tout ou partie desdites marchandises et que tous services prévus aux présentes seront assujettis à toutes les conditions auxquelles, par renvoi, sont intégrées aux présentes et ont la même force et le même effet que si elles étaient énoncées séparément, et intégralement et expressément.

1. Le Règlement sur la responsabilité à l'égard du transport ferroviaire de marchandises (DORC/91 468, 14 août 1991) adoptée en vertu de la loi de 1987 sur les transports nationaux
2. du connaissance du transporteur maritime, conformément aux dispositions et règlements énoncés dans les tarifs s'appliquant au transport par eau; ou
3. du connaissance prescrit par les tarifs, classifications, statuts et règlements se rapportant aux services de camionnage si lesdites marchandises sont transportées par camion; ou
4. du connaissance selon l'annexe 2 du Décret 47-88 du 13 janvier 1988, si ses marchandises sont expédiées de la province de Québec par camion;
5. approuvées par l'ordonnance générale No. T-43 de la Commission Canadienne des Transports pour le Canada régissant le transport des messageries et marchandises de détail et dont le texte peut être obtenu sur demande à toutes les gares de voyageurs et de messageries, ainsi qu'à tous les dépôts de marchandises si lesdites marchandises sont transportées par un voiturier du rail, conditions auxquelles l'expéditeur consent et qu'il accepte pour lui-même et ses ayants droit

Consigned To: DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7  
CANADA

S/O: 132699

Freight: Prepaid

| No   | Description Of Articles              | LTL | Haz | Net                    | Tare              | Gross                  |
|------|--------------------------------------|-----|-----|------------------------|-------------------|------------------------|
| Pkgs |                                      | Cls | Mat |                        |                   |                        |
| 6    | Aluminum Lineal Shapes; Item 13515-A | 60  |     | 2,317 lbs<br>1,051 kgs | 106 lbs<br>48 kgs | 2,423 lbs<br>1,099 kgs |

44x2  
42x3  
35

|   |       |                        |                   |                        |
|---|-------|------------------------|-------------------|------------------------|
| 6 | TOTAL | 2,317 lbs<br>1,051 kgs | 106 lbs<br>48 kgs | 2,423 lbs<br>1,099 kgs |
|---|-------|------------------------|-------------------|------------------------|

Shipper, Per T1TONKS  
SIGNATURE ALUMINUM CANADA  
1850 CLEMENTS ROAD  
PICKERING ON L1W 3R8

CANADA

|                 |     |     |     |                           |     |     |     |
|-----------------|-----|-----|-----|---------------------------|-----|-----|-----|
| CARRIER / AGENT |     |     |     | CONSIGNEE / CONSIGNATAIRE |     |     |     |
| DATE            | D/J | M/M | Y/A | DATE                      | D/J | M/M | Y/A |
| PER / PAR       |     |     |     | PER / PAR                 |     |     |     |

Visit us at [www.signaturealum.com](http://www.signaturealum.com)

FORM NO. B1018 REV. C

**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD  
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

| Cert Date  | Cert No. | Sales Order | Page     |
|------------|----------|-------------|----------|
| 08/12/2018 | 5491642  | 132699      | 1        |
| Cust PO    | B/L No   | Lot         | Date     |
| PO040296   | 038877   | 903813      | 08/20/18 |

| Sold To                                                                               | Ship To                                                                               |
|---------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|
| 46024<br>DART AEROSPACE LTD.<br>1270 ABERDEEN ST.<br>HAWKESBURY, ON K6A 1K7<br>CANADA | 46024<br>DART AEROSPACE LTD.<br>1270 ABERDEEN ST.<br>HAWKESBURY, ON K6A 1K7<br>CANADA |

| Item No                       | Part No                            | Item Description  | Cust Part   |
|-------------------------------|------------------------------------|-------------------|-------------|
| 002                           | DAA-897123-2                       | 10FT MILL 6061 T6 | D2622-120CP |
| Gross Weight                  | 2,423 LBS                          |                   |             |
| Net Qty                       | 2,317 LBS      259 PCS      6 PKGS |                   |             |
| Specification                 | Die Desc                           |                   |             |
| AMS-QQ-A-200/8 & ASTM B221-08 |                                    |                   |             |

**Mechanical Tests:**

| <u>Tensile</u>   | <u>Yield</u>     |                     |                     |            |
|------------------|------------------|---------------------|---------------------|------------|
| <u>MPA / KSI</u> | <u>MPA / KSI</u> | <u>% Elongation</u> | <u>Conductivity</u> | <u>HRE</u> |
| 286.2 / 41.5     | 253.8 / 36.8     | 11.0                | N/A                 | 93         |

**Chemical Analysis:**

| <u>Si</u> | <u>Fe</u> | <u>Cu</u> | <u>Mn</u> | <u>Mg</u> | <u>Cr</u> | <u>Zn</u> | <u>Ti</u> | <u>V</u> | <u>Zr</u> |
|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|----------|-----------|
| 0.59      | 0.23      | 0.21      | 0.08      | 0.88      | 0.08      | 0.05      | 0.01      | 0.01     | 0.00      |

*This Material is Made in Canada**This Material is RoHS Compliant*

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Gooder  
Quality Manager  
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at [www.signaturealum.com](http://www.signaturealum.com)

Rev A



## MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2622-120  
 DATE: 18/08/21

PO / BATCH NO.: P0040296/S104007

MATERIAL CERT REC'D: Yes  
 QUANTITY RECEIVED: 259  
 QUANTITY INSPECTED: 259  
 QUANTITY REJECTED: 0

THICKNESS ORDERED: \_\_\_\_\_  
 THICKNESS RECEIVED: \_\_\_\_\_  
 SHEET SIZE ORDERED: \_\_\_\_\_  
 SHEET SIZE RECEIVED: \_\_\_\_\_

| DESCRIPTION                                     | NCR<br>(Check Y/N)                 |                                    | COMMENTS        |
|-------------------------------------------------|------------------------------------|------------------------------------|-----------------|
| SURFACE DAMAGE                                  | Y                                  | <input checked="" type="radio"/> N |                 |
| CORRECT FINISH                                  | <input checked="" type="radio"/> Y | N                                  |                 |
| CORROSION                                       | Y                                  | <input checked="" type="radio"/> N |                 |
| CORRECT GRAIN DIRECTION                         | <input checked="" type="radio"/> Y | N                                  |                 |
| CORRECT MATERIAL PER M-DRAWING                  | <input checked="" type="radio"/> Y | N                                  | ASTM-A240-2001B |
| CORRECT THICKNESS                               | <input checked="" type="radio"/> Y | N                                  |                 |
| PHOTO REQUIRED                                  | Y                                  | <input checked="" type="radio"/> N |                 |
| CORRECT REF # TO LINK CERT                      | <input checked="" type="radio"/> Y | N                                  | P0040296        |
| CORRECT MATERIAL IDENTIFICATION                 | <input checked="" type="radio"/> Y | N                                  |                 |
| CORRECT M# ON THE MATERIAL                      | <input checked="" type="radio"/> Y | N                                  |                 |
| DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF | Y                                  | <input checked="" type="radio"/> N |                 |
| DOES THIS REQUIRE AN EXTRUSION REPORT           | Y                                  | <input checked="" type="radio"/> N |                 |

| CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK.<br>RECORD RESULTS BELOW |     |     |       |       |         |
|------------------------------------------------------------------------------------|-----|-----|-------|-------|---------|
| TYPE OF MATERIAL<br>SIZE OF TEST SAMPLE<br>HARDNESS / DUROMETER READING            | HRC | HRB | DUR A | DUR D | WEBSTER |
|                                                                                    |     |     |       |       |         |
|                                                                                    |     |     |       |       |         |
|                                                                                    |     |     |       |       |         |

*testers located in the Quality Office*

| QC 18 INSPECTION        | ENGINEERING SIGNOFF (if required) |
|-------------------------|-----------------------------------|
| INSPECTED BY: <u>AT</u> | SIGNED OFF BY: _____              |
| DATE: <u>18/08/21</u>   | DATE: _____                       |

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in